

Work Order ID 79139

79139

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January-20-12 1:42:22 PM

Item ID: D4269-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 20/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4269	A								

100 0.00
100
 Small Fab Memo 0.00 *8*
 Small Fab 1- Cut to length and the 45 degree chamfer in two place as per dwg *FF 12-01-25*

(4x)

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00 *8 12/01/25*
 Quality Control

(x4)

120 Chemical Conversion Coat per QSI005 4.1 0.00
120
 HandFinish Memo 0.00
 Hand Finishing

H 12-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79139***79139***

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January-20-12 1:42:22 PM

Item ID: D4269-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 20/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

4X UMF 12/01/25

140

Identify as per dwg & Stock Location ST 130

0.00

140

Packaging

Memo

0.00

Packaging

(4X) SP 12-01-26

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/1/30

UMF
12-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79139

79139

Parent Item: D4269-1

D4269-1

Parent Item Name: Angle

Start Date: 20/01/2012

Required Date: 03/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A.750X.750X. 063W		Purchased	No			100	f	23.9330	0.336	1.414737			

M2024T3A 750X 750X 063W

**

Angle2024T3511 .750 x .750 x .063w

Location

Loc Qty

Loc Code

MAT028

23.933

103509

22.164

116909

1.769

103509

FF

12-01-25

4x

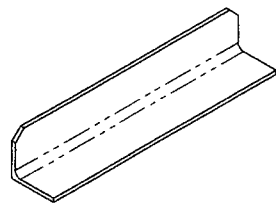
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

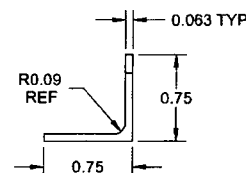
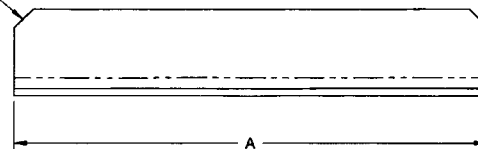
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



0.16 x 45°
CHAMFER
2 PL



D4269-X
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	A	WEIGHT
D4269-1	ANGLE	EA20469-33	4.03	0.04
D4269-3	ANGLE	EA20469-30	4.63	0.04

NOTES:

- MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- WEIGHT: SEE TABLE

SHOP ONLY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO REVISION
W/OUT NOTICE
WG. ORDER
NO. 79139

M.L.J
12/01/20

RELEASED
2011-04-06
WNI

REV.	NEW ISSUE	DESCRIPTION	RF	10.11.22
DESIGN	RF			
DRAWN	RF			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.11.22			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4269	SHEET 1 OF 2
TITLE VRD PARTS	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

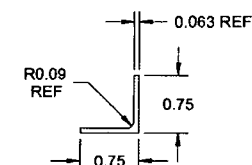
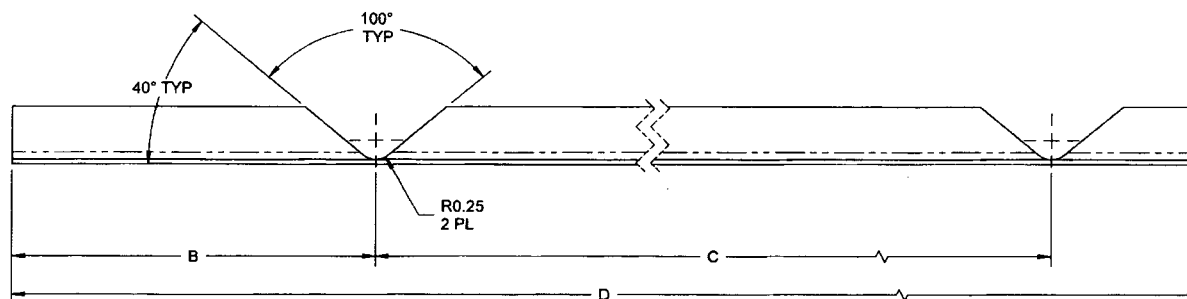
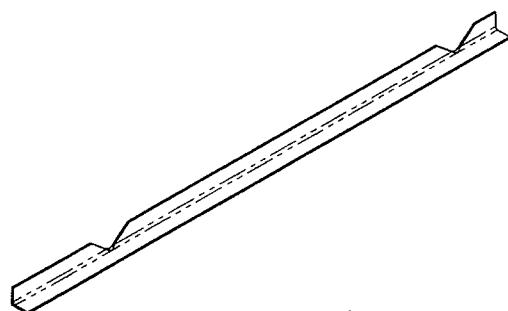
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D4269-Z
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4269	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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